

Work Order ID 100786

May 1, 2013 7:20:00 AM

100786

Page 1

Item ID: D3884-1

BS
B218

Accept

N900040100

Setup Start

NS1

Revision ID:

Item Name: Saddle, Inboard LH

Stop

NS2

Start Date: 5/13/13

Start Qty: 6.00

6

Cust Item ID:

Required Date: 5/17/13

Req'd Qty: 6.00

6

Customer:

Reference:

Approvals: Process Plan:

H

Date: B-05-1

Tooling:

Date:

Run Start

NR1

QC:

Date:

SPC (Y/N):

Date:

Stop

NR2

Draw Nbr	Revision Nbr	Tooling	SPC (Y/N)	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
----------	--------------	---------	-----------	------------	------------	---------------	-------------

D3884	B						
100							
100		HAAS CNC VERTICAL MACHINING #1					

HAAS I
HAAS CNC vertical machine #1

Memo

0.00

Program Batch No. 100786

Double check by: SK

1-Machine Step No 1 per Folio FA818 and inspect per attached Dimension

Sheets

2-Machine Step No 2 per Folio FA818 and inspect per attached Dimension

Sheets

3-Machine Step No 3 per Folio FA818 and inspect per Dimension Sheets

DAS
40
9-89

13/07/14

6

∅

110	QC2- Inspect parts off machine FAI/FAIB	0.00					
110							
QC	Memo	0.00					

Quality Control

DAS
40
9-89

13/07/14

6

∅

NCR: Yes / No

DQA: _____ Date: _____

WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order: _____			DISPOSITION		AGAINST DEPARTMENT/PROCESS					
			Rework <input type="checkbox"/>	Skid-tube <input type="checkbox"/>	Crosstube <input type="checkbox"/>	Water Jet <input type="checkbox"/>	Engineering <input type="checkbox"/>			
			Scrap <input type="checkbox"/>	Machining <input type="checkbox"/>	Small Fab <input type="checkbox"/>	Prod. Eng. Coor. <input type="checkbox"/>	Quality <input type="checkbox"/>			
			Use-as-is <input type="checkbox"/>	Thermoforming <input type="checkbox"/>	Finishing <input type="checkbox"/>	Rec/Store/Packaging <input type="checkbox"/>	Other <input type="checkbox"/>			
			Work Order Update <input type="checkbox"/>	Large Fab <input type="checkbox"/>	Composite <input type="checkbox"/>	Supplier <input type="checkbox"/>				
Root Cause	Date	Step	Qty	Description of work order update or Non-conformance	Initial Chief Eng	Action Description	Sign & Date	Verification	QC Inspector	
Doc/Data										
Equip/Tooling										
Operator										
Material										
Setup										
Other										
Process										
Supplier										
Training										
Unapproved										
FAULT CATEGORY										
Landing Gear	General									
	Bending <input type="checkbox"/>	Bend <input type="checkbox"/>	Grain <input type="checkbox"/>	Ovalized <input type="checkbox"/>	Pressure/Forced <input type="checkbox"/>					
	Centre Not Concentric to O/S <input type="checkbox"/>	BOM/Route <input type="checkbox"/>	Hardware <input type="checkbox"/>	Over/Under tolerance <input type="checkbox"/>	Temperature/Cure <input type="checkbox"/>					
	Cracks <input type="checkbox"/>	Broken/Damaged <input type="checkbox"/>	Inspection Incomplete <input type="checkbox"/>	Part Incorrect <input type="checkbox"/>	Weld <input type="checkbox"/>					
	Crushed/Crimped. <input type="checkbox"/>	Burrs <input type="checkbox"/>	Instructions Incomplete/Unclear <input type="checkbox"/>	Part Lost/Missing <input type="checkbox"/>	Wrong Stock Pulled <input type="checkbox"/>					
	Cuffs <input type="checkbox"/>	Contamination <input type="checkbox"/>	Maintenance <input type="checkbox"/>	Part Moved <input type="checkbox"/>						
	Heat Treat <input type="checkbox"/>	Countersink <input type="checkbox"/>	Mislabeled <input type="checkbox"/>	Positioned Wrong <input type="checkbox"/>						
	Inspection Strip in Tube <input type="checkbox"/>	Cut Too Short <input type="checkbox"/>	Misread <input type="checkbox"/>	Power Loss/Surge <input type="checkbox"/>	Other <input type="checkbox"/>					
	Ripples in Bend <input type="checkbox"/>	Drill Holes <input type="checkbox"/>	Offset <input type="checkbox"/>							
	Torque Waves in Extrusion <input type="checkbox"/>	Drawing <input type="checkbox"/>	Out of Calibration <input type="checkbox"/>							
	Turning Sequence <input type="checkbox"/>	Finish <input type="checkbox"/>	Out of Sequence <input type="checkbox"/>							
	Wave/Twist in Tube <input type="checkbox"/>	Folio <input type="checkbox"/>	Outside Dimensions <input type="checkbox"/>							

Work Order ID 100786

May 1, 2013 7:20:00 AM

100786

Page 2

Item ID: D3884-1

Accept

N900040100

Setup Start

NS1

Revision ID:

Item Name: Saddle, Inboard LH

Stop

NS2

Start Date: 5/13/13 Start Qty: 6.00

6

Cust Item ID:

Required Date: 5/17/13 Req'd Qty: 6.00

6

Customer:

Reference:

Approvals: Process Plan:

Date:

Tooling:

Date:

Run Start

NR1

QC:

Date:

SPC (Y/N):

Date:

Stop

NR2

Seq# Work Center ID

120

120

QC

Quality Control

Operation Description

QC8- Inspect parts - second check

Up/ Run Hours

0.00

02/13/16

6 8

130

130

HandFinish

Hand Finishing

Chemical Conversion Coat per QSI005 4.1

0.00

6 7/13/16

140

140

Powdercoat

Powder Coating

White Gloss(Ref 4.3.5.1) per QSI005 4.3-Alum

0.00

Memo

845. 0.00

START TIME:

220°

OVEN TEMPERATURE:

915

FINISH TIME:

6 8/13/17.

NCR: Yes / No

DQA: Date: _____

WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order ID 100786

May 1, 2013 7:20:00 AM

100786

Page 3

Item ID: D3884-1

Accept

N900040100

Setup Start

NS1

Revision ID:

Item Name: Saddle, Inboard LH

Stop

NS2

Start Date: 5/13/13 Start Qty: 6.00

6

Cust Item ID:

Required Date: 5/17/13 Req'd Qty: 6.00

6

Customer:

Reference:

Approvals: Process Plan:

Date:

Tooling:

Date:

Run Start

NR1

QC:

Date:

SPC (Y/N):

Date:

Stop

NR2Sequence #
Work Center IDOperation
DescriptionSet Up/
Run Hours

Tool ID

Tool #

Plan

Code

Accept.

Reject.

Reject.

Reject.

Inspec.

Number

Stamp

150

150

QC

Quality Control

QC3- Inspect Part Finish

0.00

0.00

0.00

0.00

0.00

0.00

0.00

0.00

0.00

0.00

0.00

0.00

0.00

0.00

0.00

0.00

0.00

0.00

0.00

0.00

160

160

Packaging

Packaging

Identify as per dwg & Stock Location: ST430

0.00

0.00

6x

11.13-07-17

170

170

QC

Quality Control

QC21- Final Inspection - Work Order Release

0.00

Memo

0.00

MCJ 13-07-19

JMF

13-7-18

NCR: Yes / No

DQA: _____ Date: _____

WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order: _____		DISPOSITION		AGAINST DEPARTMENT/PROCESS					
Part No. _____		Rework <input type="checkbox"/>	Skid-tube <input type="checkbox"/>	Crosstube <input type="checkbox"/>	Water Jet <input type="checkbox"/>	Engineering <input type="checkbox"/>			
NCR No. _____		Scrap <input type="checkbox"/>	Machining <input type="checkbox"/>	Small Fab <input type="checkbox"/>	Prod. Eng. Coor. <input type="checkbox"/>	Quality <input type="checkbox"/>			
		Use-as-is <input type="checkbox"/>	Thermoforming <input type="checkbox"/>	Finishing <input type="checkbox"/>	Rec/Store/Packaging <input type="checkbox"/>	Other <input type="checkbox"/>			
		Work Order Update <input type="checkbox"/>	Large Fab <input type="checkbox"/>	Composite <input type="checkbox"/>	Supplier <input type="checkbox"/>				
Root Cause	Date	Step	Qty	Description of work order update or Non-conformance	Initial Chief Eng	Action Description	Sign & Date	Verification	QC Inspector
Doc/Data									
Equip/Tooling									
Operator									
Material									
Setup									
Other									
Process									
Supplier									
Training									
Unapproved									
FAULT CATEGORY									
Landing Gear <input type="checkbox"/> Bending <input type="checkbox"/> Centre Not Concentric to O/S <input type="checkbox"/> Cracks <input type="checkbox"/> Crushed/Crimped <input type="checkbox"/> Cuffs <input type="checkbox"/> Heat Treat <input type="checkbox"/> Inspection Strip in Tube <input type="checkbox"/> Ripples in Bend <input type="checkbox"/> Torque Waves in Extrusion <input type="checkbox"/> Turning Sequence <input type="checkbox"/> Wave/Twist in Tube				General <input type="checkbox"/> Bend <input type="checkbox"/> BOM/Route <input type="checkbox"/> Broken/Damaged <input type="checkbox"/> Burrs <input type="checkbox"/> Contamination <input type="checkbox"/> Countersink <input type="checkbox"/> Cut Too Short <input type="checkbox"/> Drill Holes <input type="checkbox"/> Drawing <input type="checkbox"/> Finish <input type="checkbox"/> Folio <input type="checkbox"/> Grain <input type="checkbox"/> Hardware <input type="checkbox"/> Inspection Incomplete <input type="checkbox"/> Instructions Incomplete/Unclear <input type="checkbox"/> Maintenance <input type="checkbox"/> Mislabeled <input type="checkbox"/> Misread <input type="checkbox"/> Offset <input type="checkbox"/> Out of Calibration <input type="checkbox"/> Out of Sequence <input type="checkbox"/> Outside Dimensions					
				<input type="checkbox"/> Ovalized <input type="checkbox"/> Over/Under tolerance <input type="checkbox"/> Part Incorrect <input type="checkbox"/> Part Lost/Missing <input type="checkbox"/> Part Moved <input type="checkbox"/> Positioned Wrong <input type="checkbox"/> Power Loss/Surge <input type="checkbox"/> Other					
				<input type="checkbox"/> Pressure/Forced <input type="checkbox"/> Temperature/Cure <input type="checkbox"/> Weld <input type="checkbox"/> Wrong Stock Pulled					

Picklist Print

May 1, 2013 7:20:00 AM

Page 1

Work Order ID: 100786

Parent Item: D3884-1

Parent Item Name: Saddle, Inboard LH

Start Date: 5/13/13

Required Date: 5/17/13

Start Qty: 6.00

Required Qty: 6.00

Comments: IPP RevA: New issue DD verified by:EC

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
---------------------------------	------------------------	---------------	-------------	---------------------	------------------	-----------------	--------------------	----------------	-------------	--------------	---------------	----------------	--------

D6101-017 Saddle Billet		Manufactured	No				Each	11.0000		6	DAS 40 9.60	13/07/14	
----------------------------	--	--------------	----	--	--	--	------	---------	--	---	-------------------	----------	--

Location	Loc Qty	Loc Code
MAT040	11	
Q4444	11	

102959

6

NCR: Yes / No

DQA: Date:

WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order: _____			DISPOSITION			AGAINST DEPARTMENT/PROCESS					
			Rework <input type="checkbox"/>	Skid-tube <input type="checkbox"/>	Crosstube <input type="checkbox"/>	Water Jet <input type="checkbox"/>	Engineering <input type="checkbox"/>				
Part No. _____			Scrap <input type="checkbox"/>	Machining <input type="checkbox"/>	Small Fab <input type="checkbox"/>	Prod. Eng. Coor. <input type="checkbox"/>	Quality <input type="checkbox"/>				
NCR No. _____			Use-as-is <input type="checkbox"/>	Thermoforming <input type="checkbox"/>	Finishing <input type="checkbox"/>	Rec/Store/Packaging <input type="checkbox"/>	Other <input type="checkbox"/>				
Root Cause		Date	Step	Qty	Description of work order update or Non-conformance	Initial Chief Eng	Action Description	Sign & Date	Verification	QC Inspector	
Doc/Data	<input type="checkbox"/>										
Equip/Tooling	<input type="checkbox"/>										
Operator	<input type="checkbox"/>										
Material	<input type="checkbox"/>										
Setup	<input type="checkbox"/>										
Other	<input type="checkbox"/>										
Process	<input type="checkbox"/>										
Supplier	<input type="checkbox"/>										
Training	<input type="checkbox"/>										
Unapproved	<input type="checkbox"/>										
FAULT CATEGORY											
Landing Gear			General								
			Bending <input type="checkbox"/>	Bend <input type="checkbox"/>	Grain <input type="checkbox"/>	Ovalized <input type="checkbox"/>	Pressure/Forced <input type="checkbox"/>				
Centre Not Concentric to O/S <input type="checkbox"/>	BOM/Route <input type="checkbox"/>	Hardware <input type="checkbox"/>	Over/Under tolerance <input type="checkbox"/>	Temperature/Cure <input type="checkbox"/>							
Cracks <input type="checkbox"/>	Broken/Damaged <input type="checkbox"/>	Inspection Incomplete <input type="checkbox"/>	Part Incorrect <input type="checkbox"/>	Weld <input type="checkbox"/>							
Crushed/Crimped <input type="checkbox"/>	Burrs <input type="checkbox"/>	Instructions Incomplete/Unclear <input type="checkbox"/>	Part Lost/Missing <input type="checkbox"/>	Wrong Stock Pulled <input type="checkbox"/>							
Cuffs <input type="checkbox"/>	Contamination <input type="checkbox"/>	Maintenance <input type="checkbox"/>	Part Moved <input type="checkbox"/>								
Heat Treat <input type="checkbox"/>	Countersink <input type="checkbox"/>	Mislabeled <input type="checkbox"/>	Positioned Wrong <input type="checkbox"/>								
Inspection Strip in Tube <input type="checkbox"/>	Cut Too Short <input type="checkbox"/>	Misread <input type="checkbox"/>	Power Loss/Surge <input type="checkbox"/>								
Ripples in Bend <input type="checkbox"/>	Drill Holes <input type="checkbox"/>	Offset <input type="checkbox"/>									
Torque Waves in Extrusion <input type="checkbox"/>	Drawing <input type="checkbox"/>	Out of Calibration <input type="checkbox"/>									
Turning Sequence <input type="checkbox"/>	Finish <input type="checkbox"/>	Out of Sequence <input type="checkbox"/>									
Wave/Twist in Tube <input type="checkbox"/>	Folio <input type="checkbox"/>	Outside Dimensions <input type="checkbox"/>									

DART AEROSPACE LTD				Work Order: 100716	
Description: Saddle, Inboard, LH				Part Number: D3884-1	
Inspection Dwg: D3884 Rev. B				Page 1 of 1	

Inspect dimensions highlighted on inspection sheet drawing and record below:

Dim	Min	Max	Go/No Go Gauge	Recorded Actual Dimensions				By	Date
				1	2	3	4		
A	2.870	2.880		2.875	2.875	2.875	2.875		
B	1.433	1.443		1.438	1.438	1.438	1.438		
C	0.638	0.658		.649	.647	.649	.647		
D	3.895	3.905		3.900	3.900	3.900	3.900		
E	0.257	0.262		.258	.258	.258	.258		
F	0.605	0.625		.615	.615	.617	.615		
G	1.120	1.130		1.125	1.125	1.125	1.125		
H	2.245	2.255		2.250	2.250	2.250	2.250		
I	2.000	2.020		2.000	2.007	2.007	2.009		
J	0.140	0.175		.144	.145	.144	.145		
K	1.265	1.285		1.266	1.267	1.2697	1.2687		
L	0.115	0.135		.123	.124	.125	.125		
M	0.240	0.260		.248	.249	.250	.250		
N	0.110	0.140		.140	.140	.140	.140		
O	0.240	0.260		.254	.251	.252	.257		
P	2.826	2.886		2.865	2.865	2.865	2.865		
Q	0.178	0.198		.188	.188	.188	.188		
R	0.140	0.165		.150	.150	.149	.151		
S	0.720	0.780		.765	.765	.765	.765		
T	1.220	1.280		1.260	1.260	1.260	1.260		
U	1.245	1.255		1.250	1.250	1.250	1.250		
V	5.990	6.010		6.003	6.003	6.003	6.003		
W	2.495	2.505		2.500	2.500	2.500	2.500		
X	0.490	0.510		.500	.499	.500	.501		
Y	0.020	0.040		.035	.035	.035	.035		
Z	0.313	0.318		.314	.314	.314	.314		
AA	0.760	0.765		.760	.760	.760	.760		
AB	0.215	0.220		.217	.217	.217	.217		
AC	0.316	0.321		.316	.316	.316	.316		
AD	1.745	1.755		1.750	1.750	1.750	1.750		
AE	0.990	1.010		1.001	1.000	1.002	1.000		
AF									

Accept/Reject **DAS**

40

Measured by:	40	Audited by:	On
Date:	13/07/14	Date:	13/07/14

Rev	Date	Change	Revised by	Approved
A	09.10.22	New Issue	KJ	On

DART AEROSPACE LTD

Work Order:

100786

Description: Saddle, Inboard, LH

Part Number:

D3884-1

Inspection Dwg: D3884

Rev. B

Page 1 of 1

Inspect dimensions highlighted on inspection sheet drawing and record below:

Dim	Min	Max	Go/No Go Gauge	Recorded Actual Dimensions				By	Date
				5	6	3	4		
A	2.870	2.880		2.875	2.875				
B	1.433	1.443		1.438	1.438				
C	0.638	0.658		.648	.647				
D	3.895	3.905		3.900	3.900				
E	0.257	0.262		.258	.258				
F	0.605	0.625		.615	.615				
G	1.120	1.130		1.125	1.125				
H	2.245	2.255		2.250	2.250				
I	2.000	2.020		2.006	2.006				
J	0.140	0.175		.143	.143				
K	1.265	1.285		1.270	1.270				
L	0.115	0.135		.116	.116				
M	0.240	0.260		.251	.251				
N	0.110	0.140		.140	.140				
O	0.240	0.260		.250	.249				
P	2.826	2.886		2.815	2.865				
Q	0.178	0.198		.188	.180				
R	0.140	0.165		.149	.150				
S	0.720	0.780		.765	.765				
T	1.220	1.280		1.260	1.260				
U	1.245	1.255		1.250	1.250				
V	5.990	6.010		6.003	6.003				
W	2.495	2.505		2.500	2.500				
X	0.490	0.510		.498	.498				
Y	0.020	0.040		.035	.035				
Z	0.313	0.318		.314	.314				
AA	0.760	0.765		.760	.760				
AB	0.215	0.220		.217	.217				
AC	0.316	0.321		.316	.316				
AD	1.745	1.755		1.750	1.750				
AE	0.990	1.010		1.001	.999				
AF									

Accept/Reject *DAS*

40

9-89

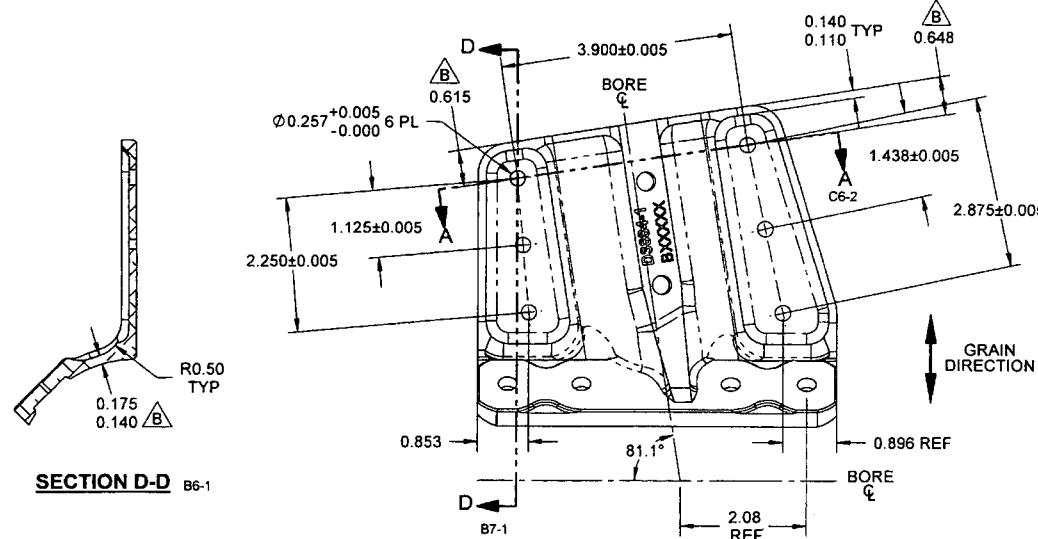
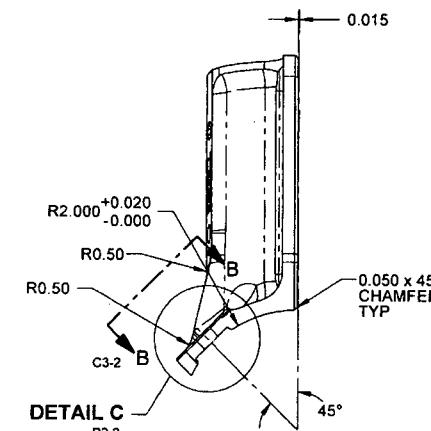
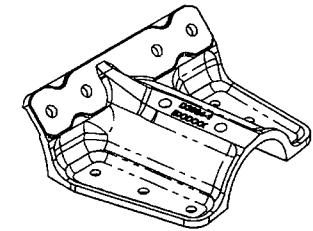
Measured by:	<i>9-89</i>
Date:	13/07/15

Audited by

CHL
13/07/15

Rev	Date	Change	Revised by	Approved
A	09.10.22	New Issue	<i>KJ</i>	<i>CHL</i>

8 1 7 6 5 4 3 2 1

100184
PL13-051RELEASED
01/17/14D3884-1 SADDLE, INBOARD LH (SHOWN)
D3884-2 SADDLE, INBOARD RH (OPPOSITE)

NOTES:

- 1) MATERIAL: 7075-T7351 ALUMINUM PER QQ-A-250/12 OR AMS-QQ-A-250/12
- 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
POWDER COAT "WHITE" (4.3.5.1) PER DART QSI 005 4.3
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: ENGRAVE PART AND BATCH NUMBER IN THIS AREA TO
MAX. DEPTH OF 0.010 WITH A MIN. TOOL RAD OF R0.010
- 7) WEIGHT: 0.71 lbs

B	D6101-017 WAS D6102-017, ZN A6-1; ADD NOTE .ZN C4-2; ADD R0.031, ZN B7-1; INCREASED TOLERANCE 0.175 WAS 0.165, ZN B7-1; ADD 0.615, ZN C6-1, ADD 0.648, ZN C4-1; ADD 0.250, ZN D6-2; ADD 0.080, ZN C2-2; 0.75 WAS 0.65, ZN D7-2		RF	09.06.30
A	NEW ISSUE		RF	09.03.30
REV.	DESCRIPTION		BY	DATE
DESIGN	DART AEROSPACE USA, INC.			
DRAWN	PORT HADLOCK, WA			
CHECKED	REV. B			
MFG. APPR.	D3884			
APPROVED	SHEET 1 OF 2			
DE APPR.	TITLE		SCALE	
DATE	INBOARD SADDLE		NTS	
	DATE 09.06.30			

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